

Work Order ID 63700

November 10, 2010 10:48:04 AM

ASAP



Page 1

Item ID: D212-725-1-069

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 11/10/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev B

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg
2-Make radius as per dwg and deburr

✱

10/11/15

ⓧ2

4

Pto →

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10

12

ⓧ

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) 11 10/11/17

2 d

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-725-1-069 PAR #: Fault Category: Small Fcks NCR: Yes No DQA: Date: 10/11/16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 10/11/17

NCR: 63700		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/16	#100	Qty x1 Part scrap. operator was cutting in Barrow and Piece got caught in Blade causing a cut in	JS1042	→ scrap + Destroy replace qty x1 M116085	JS 10/11/16	S 10/11/16	JS1042	S 10/11/16
		The Part in wrong location P.C. Process	JS1042					

NOTE: Date & initial all entries

Work Order ID 63700

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Page 2

Item ID: D212-725-1-069

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Item Name: Stiffener

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Start Date: 11/10/10 Start Qty: 2.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 10-11-17

140

Identify as per dwg & Stock Location: 374

0.00



Packaging

Memo

0.00

Packaging

2 12/4/17 (2)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CH 10/11/17 (2)
BR 10-11-17 (2)

Picklist Print

November 10, 2010 10:49:39 AM

Page 1

Work Order ID: 63700

Parent Item: D212-725-1-069

Parent Item Name: Stiffener



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.28 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A1.5X1.5X.06 3		Purchased	No				f	12.0000	2	2			



7075T6 ANGLE 1.5" X 1.5" X .063"W



Location

Loc Qty

Loc Code

MAT

12

116085

12

~~8.5~~
4.5



10/11/15

DART AEROSPACE LTD		Work Order: 63700
STIFFENER		
Description: D212 725-1		Part Number: D212 725 069
Inspection Dwg: D212 Rev: B		Page 1 of 1

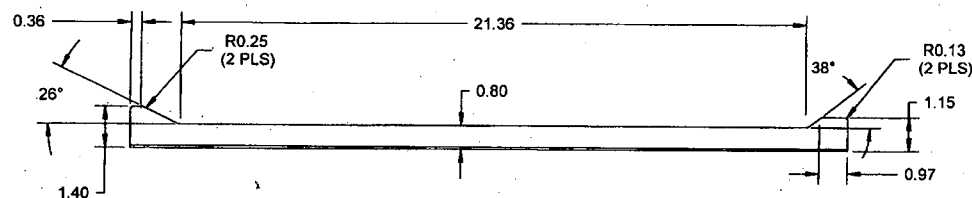
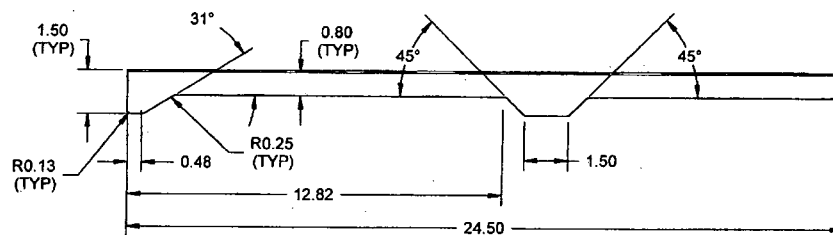
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.50	$\pm .030$	24.49	—		RA 21	T-M
.48	$\pm .030$.490	—		RA 26	vern
1.50	$\pm .030$	1.485	—		RA 26	"
.80	$\pm .030$.810	—		RA 26	"
12.82	$\pm .030$	12.830	—		RA 21	T-M
1.50	$\pm .030$	1.485	—		RA 26	vern
31°	$\pm .1/2^\circ$	31°	—		RA 16	Bevel Protractor
45°	$\pm 1/2^\circ$	45°	—		RA 16	"
21.36						
21.36	$\pm .030$	21.36	—		RA 21	T-M
.36	$\pm .030$.360	—		RA 26	vern
.97	$\pm .030$.980	—		RA 26	vern
26°	$\pm 1/2^\circ$	26°	—		RA 16	Bevel
38°	$\pm 1/2^\circ$	38°	—		RA 16	Bevel
1.40	$\pm .030$	1.404	—		RA 26	vern
1.15	$\pm .030$	1.16	—		RA 26	vern
R0.13	$\pm .030$	R0.13	—		Ref	
R0.25	$\pm .030$	R0.25			Ref	

Measured by: 	Audited by: 	Prototype Approval:
Date: 10/11/16	Date: 10/11/16	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D212-725-1-069 STIFFENER

NOTES:

- 1) MATERIAL: 7075-T6 (QQ-A-200/11) ANGLE 0.063 THICK
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

Mo 63760

RELEASED
2009-10-28

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1 REV. B SHEET 27 OF 44
DATE 07.05.11	TITLE 212S DETAIL PARTS	SCALE 1:4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries